

**Work Order ID 62489**

Thursday, September 30, 2010 2:23:37 PM



Page 1

Item ID: D3774-1

Accept



Setup Start



Revision ID:

Item Name: Seat Bottom, LH/RH

Stop



Start Date: 9/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/9/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3774	Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-1 □ Set up clamping frame as per folio

  
BB  
10/10/10

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

  
BB  
X2  
10/10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115



Dry Material

0.00

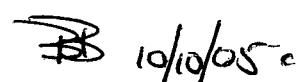
HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°FTime IN: 4:30 10/10/04Time OUT: 7:00 10/10/05


120



THERMOFORMING MACHINE

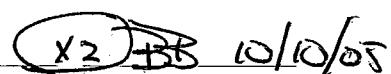
0.00

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3774-1 and Folio  Dwg. Rev.  Folio Rev. C


130



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control



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Item Name: Seat Bottom, LH/RH

Stop



Start Date: 9/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

150



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

1) Check dimensions to ensure conformity to drawing tolerances.

160



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 62489**

Page 4

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Item ID: D3774-1

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Setup

Start



Revision ID:

Item Name: Seat Bottom, LH/RH

Stop



Start Date: 9/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Identify as per dwg & Stock Location: 257

0.00

10/10/10

Packaging

Memo

0.00

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

10/10/08

QC

Memo

0.00

Quality Control

MF 10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Thursday, September 30, 2010 2:23:40 PM

Page 1

Work Order ID: 62489



Parent Item: D3774-1



Parent Item Name: Seat Bottom, LH/RH

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD  
IPP REV. B Dwg. Update 08.08.19 DL  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			110	sf	2,185.803	10.667	21.334			

GE PLASTICS LEXAN SHEET



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	2185.8038	
114032	184.9238	
115261	2000.88	

X2 B 10/10/09

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	C2489
Description: Seat Bottom	Part Number:	D3774-1
Inspection Dwg: D3774 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 10/10/05

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.36	✓			
33.9	+/-0.100	33.8	✓			
17.4	+/-0.100 Min	17.6	✓			
0.085	Min	.081	✓			
0.100	Min	.100	✓			
0.100	Min	.115	✓			
0.100	Min	.118	✓			
0.100	Min	.110	✓			

Measured by: BB

Date: 10/10/05

Audited by: DL

Date: 10/10/05

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	<u>BB</u>

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

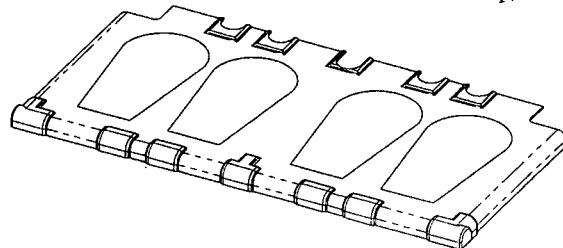
C

B

B

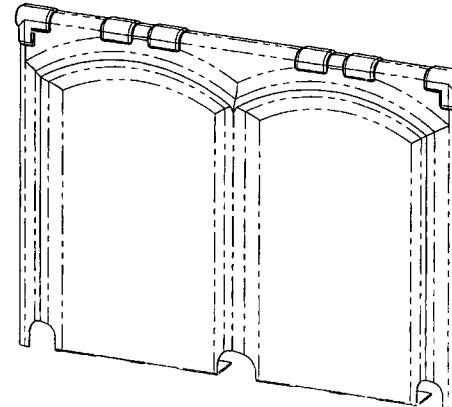
A

A



D3774-1 SEAT BOTTOM

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO ANG NUMBER  
WITHOUT NOTICE  
WORK ORDER  
NO. *624189*  
*28/10/930*



D3774-3 SEAT BACK

**RELEASED**  
*06-08-11/M*

B	UPDATE CUTCUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PH</i>	D3774	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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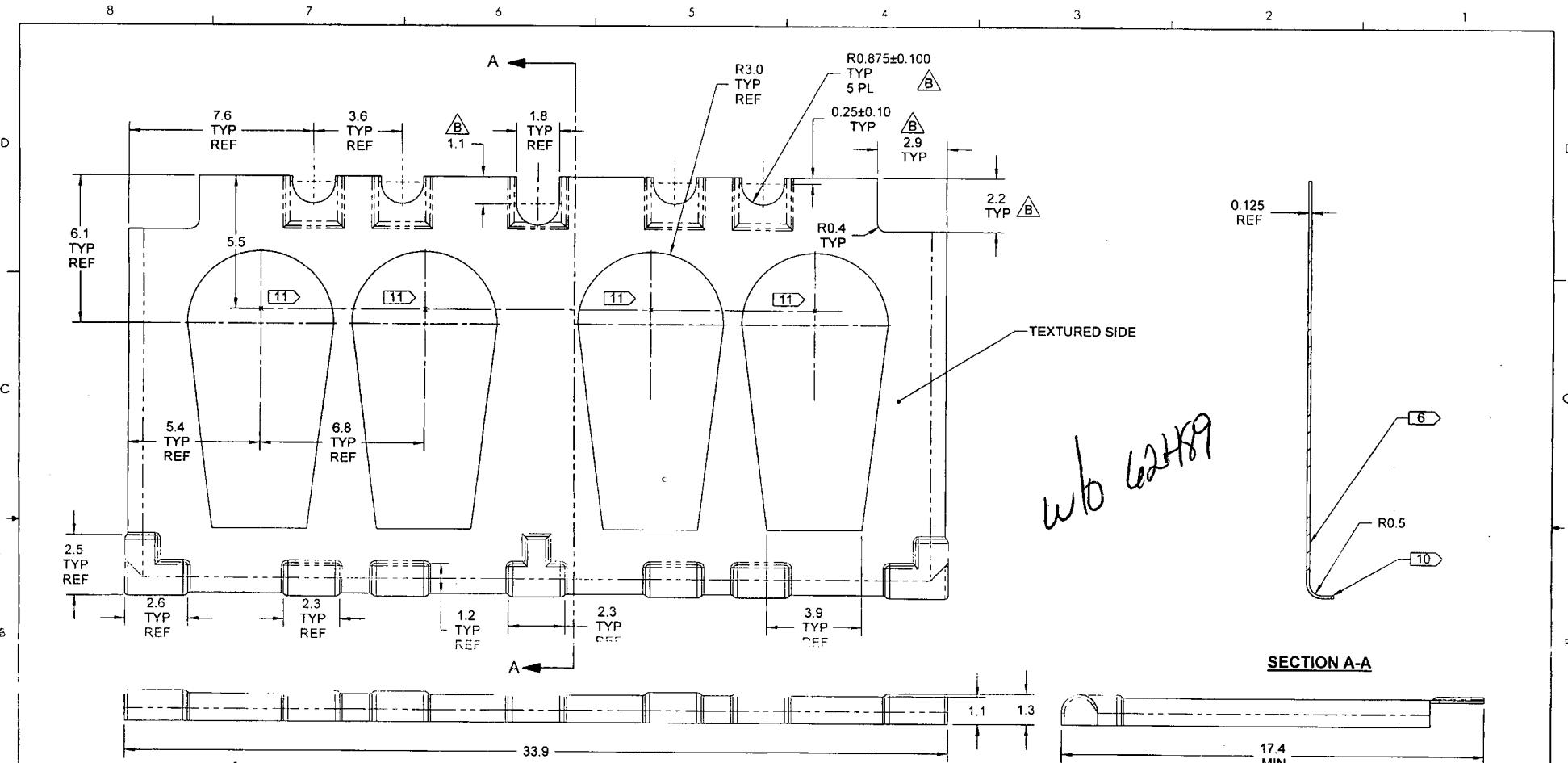
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NOTE: Date & initial all entries



### D3774-1 SEAT BOTTOM

#### NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
- 7) WEIGHT: 2.93 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED  
08-08-11-14

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	R	HAWKESBURY, ONTARIO, CANADA	
CHECKED	S		
MFG. APPR.	P	DRAWING NO.	REV. B
APPROVED	N	D3774	SHEET 2 OF 3
DE APPR.	N	TITLE	SCALE
		SEAT	NTS
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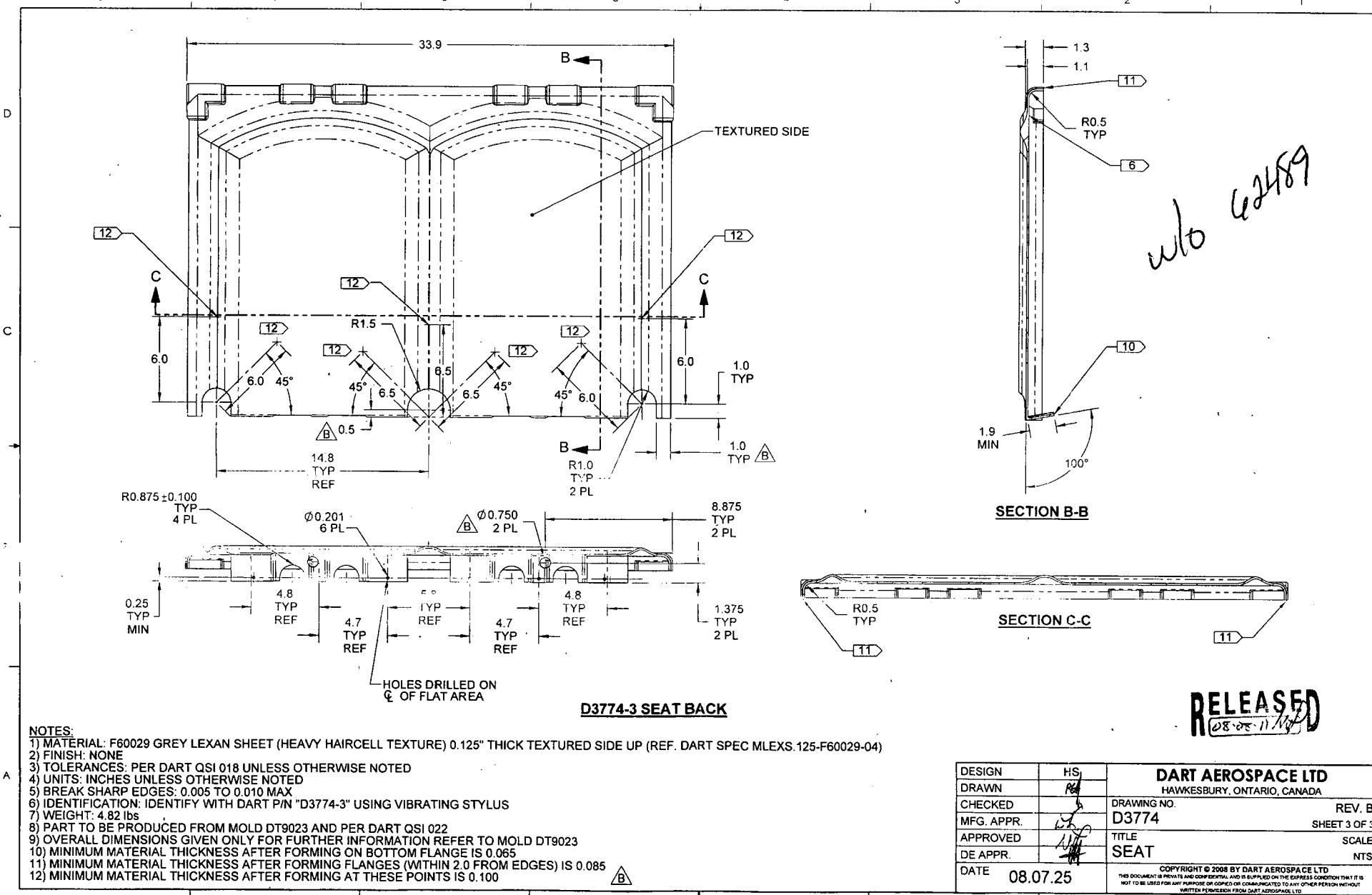
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8 7 6 5 4 3 2 1



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DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. B	
APPROVED		D3774	
DE APPR.		SHEET 3 OF 3	
DATE	08.07.25	TITLE	SCALE
		SEAT	NTS

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8 7 6 5 4 3 2 1

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